



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D6028-195
Job Sheet 183068



Part No: D6028-195

Job Qty: 21 pcs

Part Name: Crosstube Material, 7075-T73/T73511



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/12/18

Job Tracking No:

Due Date: 5/22/19

Created By: Chantal Lavoie

Type: Stock

Description:

Note: IPP Rev.A New issue JFS 17/11/03 Verified by:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
100	Purchasing	21 pcs	5/22/19	5/22/19	0.00	0.00	Purchasing - 1	DAS 61 JUN 04 2019 9-89
							Purchasing - 2 VM	
							Purchasing - 3	
110	Packaging 2-1 - Receive - B4B	21 pcs	5/22/19	5/22/19	0.00	0.00	Packaging 2 - 1 - B4B	DAS 61 JUN 04 2019 9-89
							Packaging 2 - 2 - B4B	
							Packaging 2 - 3 - B4B	
							Packaging 2 - 5 - B4B	
							Packaging 2 - 4 - B4B	
							Packaging 2 - 6 - B4B	
							Packaging 2 - 7 - B4B	
							Packaging 2 - 8 - B4B	
							Packaging 2 - 9 - B4B	
							Packaging 2 - 10 - B4B	
							Packaging 2 - 11 - B4B	
							Packaging 2 - 12 - B4B	
							Packaging 2 - 13 - B4B	
							Packaging 2 - 14 - B4B	
							Packaging 2 - 15 - B4B	
							Packaging 2 - 16 - B4B	
							Packaging 2 - 17 - B4B	
							Packaging 2 - 18 - B4B	
							Packaging 2 - 19 - B4B	
							Packaging 2 - 20 - B4B	
							Packaging 2 - 21 - B4B	
							Packaging 2 - 22 - B4B	
							Packaging 2 - 23 - B4B	
							Packaging 2 - 24 - B4B	
							Packaging 2 - 25 - B4B	
							Packaging 2 - 26 - B4B	
							Packaging 2 - 27 - B4B	
							Packaging 2 - 28 - B4B VM	

120 QC 18	21 pcs	5/22/19	0.00 0.00	Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
				QC 18 - 12	
				QC 18 - 14	
				QC 18 - 22	
				QC 18 - 25	
				QC 18 - 48	
				QC 18 - 58	
				QC 18 - 61	
				QC 18 - 9	
					DAS DAS 6-89 9-8
140 Packaging 3-1 - Stock - B4B	21 pcs	5/22/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
150 QC 21 - SA	21 pcs	5/22/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	

Part Op 100 - Issue P/O: _____ a) Extrude as per Dwg D6028 length = 195" (Ref. D6028-195) b) Material: 7075-Descriptions: T73/T73510 (QQ-A-200/11 OR AMS 4617 OR AMS 4167 OR AMS 4166 OR ASTM B241) Seamless aluminum tube c) Minimum ultimate tensile strength = 68ksi d) Minimum yield tensile yield strength = 58ksi *****TWIST: MAXIMUM 3 DEGREE OVER TOTAL LENGHT as per dwg note 3***** Ensure material certification is attached
110 - (Receive & Inspect for Damage & Mat'l Certs) Ensure material certification is attached

120 - (QC18 In-Coming Inspection Material) Ensure Material certification comply to Dwg. D6028
140 - (Identify as per dwg & Stock Location: HALL) LOCATION :LG003
150 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6028-195P	Crosstube Material, 7075-T73/T73511	21 pcs (1 ea)	100-Purchasing	S1862U

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	D6028-195P	21	21	0

Part Specifications

Specifications could not be found.

Plex 6/4/19 4:11 PM Dart.Hadley.Shannon



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Tel (613) 632-5200
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D6028-195
Job Sheet 183068



Part No: D6028-195

Job Qty: 20 ea

Part Name: Crosstube Material, 7075-T73/T73511



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/12/18

Job Tracking No:

Due Date: 5/22/19

Created By: Chantal Lavoie

Type: Stock

Description:

Note: IPP Rev.A New issue JFS 17/11/03 Verified by:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	20 pcs		5/22/19	0.00	0.00	Purchasing Start Up		UM 67
110	Packaging	20 pcs		5/22/19	0.00	0.00	Packaging2		UM JUN 03 2019
120	QC	20 pcs		5/22/19	0.00	0.00	QC18		UM AT
140	Packaging	20 pcs		5/22/19	0.00	0.00	Packaging3		
150	QC21-SA	20 Ea		5/22/19	0.00	0.00	QC21		

Part Op 100 - Issue P/O: 41102 a) Extrude as per Dwg D6028 length = 195" (Ref. D6028-195) b) Material: 7075-Descriptions: T73/T73510 (QQ-A-200/11 OR AMS 4617 OR AMS 4167 OR AMS 4166 OR ASTM B241) Seamless aluminum tube c) Minimum ultimate tensile strength = 68ksi d) Minimum yield tensile yield strength = 58ksi *****TWIST: MAXIMUM 3 DEGREE OVER TOTAL LENGHT as per dwg note 3***** Ensure material certification is attached

110 - Ensure material certification is attached

120 - Ensure Material certification comply to Dwg. D6028

140 - LOCATION :LG003

SEP 21 2018

DAS
13
9-89

X 20PCS.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6028-195P	Crosstube Material, 7075-T73/T73511	20 pcs (1 ea)	100-Purchasing	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	D6028-195P	20	0	0

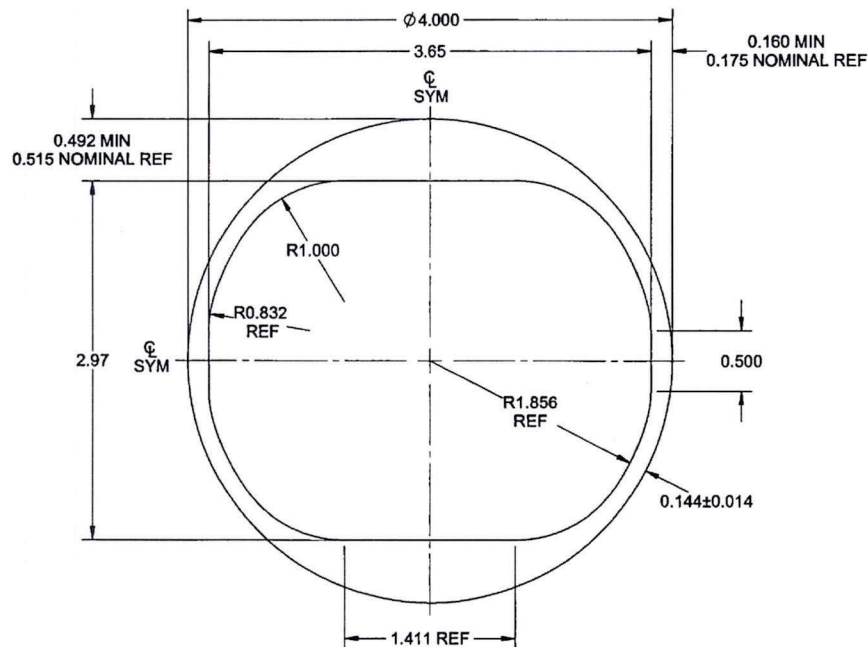
Part Specifications

Specifications could not be found.

Plex 9/12/18 7:09 AM dart.lavoie.chantal

Line 2
D6028-195

SPECIFICATION CONTROL DRAWING



D6028-XXX TUBE, SEAMLESS

WHERE XXX IS LENGTH IN INCHES
EG. 195" LONG TUBE: D6028-195

NOTES:

- 1) MATERIAL: 4.000" OD 7075-T73/T73511 SEAMLESS ALUMINUM TUBE
PER (QQ-A-200/11 OR OR AMS 4617 OR AMS 4167 OR AMS 4166 OR ASTM B241)
MINIMUM ULTIMATE TENSILE STRENGTH = 68 KSI
MINIMUM YIELD TENSILE STRENGTH = 58 KSI
- 2) FINISH: NONE
- 3) TOLERANCES: O.D.: +/- 0.016" MEAN (+/- 0.024" INCLUDING OVALITY)
LENGTH: XXX +0.5"-0.000"
STRAIGHTNESS: 0.010" DEVIATION / 12" LENGTH
TWIST: 0.25" DEVIATION / 12" LENGTH, 3" MAXIMUM OVER TOTAL LENGTH
OTHER DIMENSIONS PER DART QSI 018 EXCEPT AS NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.307 LB/IN
- 8) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE.
THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH
AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT
LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 9) MANUFACTURE PER ALUNNA DIE# XA12253

SEP 21 2018

0101183068

REV.	NO	DESCRIPTION	BY	DATE
DESIGN	NO			
DRAWN	NO			
CHECKED	AJS			
MFG. APPR.	DD			
APPROVED	WM			
DE APPR.	DS			
DATE	17.07.11			

A	NEW ISSUE	NO	17.07.11
REV.		BY	DATE
DESIGN	NO		
DRAWN	NO		
CHECKED	AJS		
MFG. APPR.	DD		
APPROVED	WM		
DE APPR.	DS		
DATE	17.07.11		

DART AEROSPACE LTD		REV. A
HAWKESBURY, ONTARIO, CANADA		
DRAWING NO.	D6028	SHEET 1 OF 1
TITLE	TUBE, SEAMLESS	SCALE
		NTS

RELEASED
2017-10-31
ECN 17-728

APPROVED

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